

Work Order ID 133268 - 2

133268

Friday, May 29, 2015 10:46:24 AM

Page 1

Item ID: D350-591-312

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Start Qty: 4.00

Required Date: 7/03/15

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-5-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002

110

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod B133508

3-Grind End Plate flush

A NON Eurocopters *

3

DAS
06
2-29

JUL 20 2015

4 CC 15-7-2

Work Order ID 133268

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Page 2

Item ID: D350-591-312

Accept

Revision ID:

N900040100Setup Start ***NS1***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***Start Date: 6/15/15 Start Qty: 4.00 ***4***Required Date: 7/03/15 Req'd Qty: 4.00 ***4***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4		JUL 13 2015	DAS 24 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4		JUL 13 2015	DAS 24 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				0			DC 15/07/13

Work Order ID 133268

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Page 3

Item ID: D350-591-312**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible**Stop *NS2*****Start Date:** 6/15/15 **Start Qty:** 4.00 ***4*****Cust Item ID:****Required Date:** 7/03/15 **Req'd Qty:** 4.00 ***4*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1***Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									15-07-13
180		0.00							
180	Large Fab								DAS 24 9-89
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>130855</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

Work Order ID 133268

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Page 4

Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***Start Date: 6/15/15 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	DAS 18 9-89	15/6/14					
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 18 9-89	15/6/14					(x4 R4)
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							(4) 15/07/14

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Item ID: D350-591-312
 Revision ID:
 Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/15/15 Start Qty: 4.00
 Required Date: 7/03/15 Req'd Qty: 4.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M131545 Memo START TIME: 9:10 OVEN TEMPERATURE: 320 FINISH TIME: 9:40	0.00 0.00				4	0	15-7-15	
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M1132 5:00 Memo	0.00							4 RH of JH 15/07/15
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00							(3) 15-07-27 DAS 9 9-89

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N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/03/15 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							

250

Packaging

Packaging

Memo

0.00

0.00

12

DA
27
9-8

JUL 20 2015



260

260

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

3

DA
64
3-3

JUL 20 2015

270

270

Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-312
Location: *Fla 22*

3

DAS	Age	Verbal	Nonverbal	Full Scale
27	9-89	6	9-89	

JUL 23 2015

Work Order ID 133268

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***Start Date: 6/15/15 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC21- Final Inspection - Work Order Release

0.00

280

QC

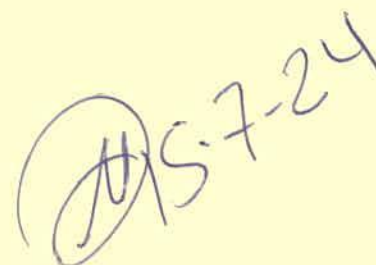
Memo

0.00

Quality Control

MLJ

JUL 24 2015



Picklist Print

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Page 1

Work Order ID: 133268

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSI 9410-011

Manufactured No

Each 1.0000

DSI 9410-011

Amends Installations OF D350-591-311/312 Steps

**

DATE
27
9:59

Location

Loc Qty

Loc Code

FG123

1

B133289

130519

1

D3272-1

Manufactured No

110

Each

0.0000

1

4

D3272-1

Step

B135105 → 4x

**

CC 15-7-2

D3067-1

Manufactured No

110

Each

48.0000

1

4

D3067-1

End Plate

**

CC 15-7-2

Location

Loc Qty

Loc Code

WA003

48

B133501 → 4x

117776

1

129522

1

131954

46

D3219-1

Manufactured No

110

Each

11.0000

2

8

D3219-1

Plate

**

CC 15-7-2

Location

Loc Qty

Loc Code

WA003

11

B133265 → 4x

129077

3

131710

8

B133392 → 4x

Picklist Print

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Page 2

Work Order ID: 133268

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

D3066-1

Manufactured No

180

Each

25.0000

2

8

D3066-1

Spacer

**

JUL 14 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

25

125436

2

131988

23

B133266 → S

MS20600-AD4W4

Purchased No

180

Each

1,050.000

16

64

MS20600-AD4W4

Rivets

**

JUL 14 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

ST308

996

M132256

996

WA003

54

M131624

54

64

D3065-041

Manufactured No

180

Each

45.0000

1

4

D3065-041

Step Leg Assembly

**

JUL 14 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

45

128423

3

129079

1

130919

20

131632

1

131777

20

3

4

Picklist Print

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Page 3

Work Order ID: 133268

133268

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazul Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

180

Each

48.0000

1

4

D3067-1

End Plate

**

JUL 14 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

48

117776

1

129522

1

131954

46

AN3-35A

Purchased

No

250

Each

74.0000

AN3-35A

Bolt

**

16

DAS
27
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST338a

50

m132344

30

ST348

14

m131886

14

D3235-1

Manufactured

No

250

Each

55.0000

D3235-1

Mounting Lug

**

16

DAS
27
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST522

52

108670

13

116385

2

129772

26

130302

2

130912

9

ST539A

3

116383

3

B13267

6

JUL 20 2015

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 133268

133268

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

D3278-041

Manufactured No

250

Each

33.0000

1

D3278-041

Support Assembly

DAS
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST523

33

130861

29

131714

4

NAS1149D0463J

Purchased

No

250

Each

5,215.000

16

NAS1149D0463.J

WASHER

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1739

M132317

1739

ST269

3435

M129682

86

M130799

371

M132035

2978

DAS
9-89

JUL 20 2015

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Page 4

Picklist Print

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Page 5

Work Order ID: 133268

133268

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

250

Each

1,836.000

4

NAS1149D0563.I

Washer

**

1612

DAS
27
9-89

8

DAS
06
9-89

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	1607	
m130799	63	
m132035	544	
<u>m132256</u>	1000	
ST269	156	
m128257	156	
ST271	20	
m131026	20	

AN5-36A

Purchased

No

250

Each

55.0000

2

AN5-36A

Bolt

**

8

DAS
27
9-89

8

DAS
06
9-89

Location

Loc Qty

Loc Code

ST299A	39	
M131957	39	
ST336	16	
M130325	1	
M130466	15	

m132551

6

D2618

Manufactured

No

250

Each

106.0000

2

D2618

Bushing

**

16

DAS
27
JUL 9-89 2015

8

DAS
06
9-89

Location

Loc Qty

Loc Code

ST008A	46	
131022	46	
ST012a	60	
<u>131614</u>	60	

6

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Shop Packet Print

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Picklist Print

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Work Order ID: 133268

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Manufactured No

250 Each

260.0000 4

D2230-3

Mounting Lug

**

DAS
27
9-89

[Handwritten signature]

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

252

114921

3

116378

1

123324

3

128799

21

130303

4

130846

80

131696

40

132403

100

[Handwritten 'R']

DAS
26
9-89

D2856-400

Manufactured No

250 f

110.4400 1.2

D2856-400

Abrasion Strip 4" Wide (Per Foot)

**

DAS
27
9-89

[Handwritten signature]

Location

Loc Qty

Loc Code

ST418

110.44

128948

110.44

[Handwritten '3.6']

JUL 20 2015

cut (2) D2856-400-720 as per dwg

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Work Order ID: 133268

133268

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

2,303.000

2

MS21042L3

Nut

**

DAS

27

9-89

DAS

86

9-89

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

503

M131317

503

ST305

1380

116549

12

126333

49

M128754

2

M132123

317

M132382

1000

AN4-13A

Purchased

No

250

Each

471.0000

8

AN4-13A

Bolt

**

DAS

27

9-89

DAS

86

9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

ST325A

427

m131957

200

m132317

227

ST344

24

131677

24

JUL 20 2015

Picklist Print

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Work Order ID: 133268

133268

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/15/15

Required Date: 7/03/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

250

Each

1,952.000

4

NAS1149D0363J

Washer

**

DAS
27
9-89

JUL 20 2015

DAS
06
9-89

Location

Loc Qty

Loc Code

CA	569	
m130799	569	
GA	222	
m128429	222	
ST269	1161	
m126319	9	
m131618	152	
<u>m132317</u>	1000	

10



DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *LE*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

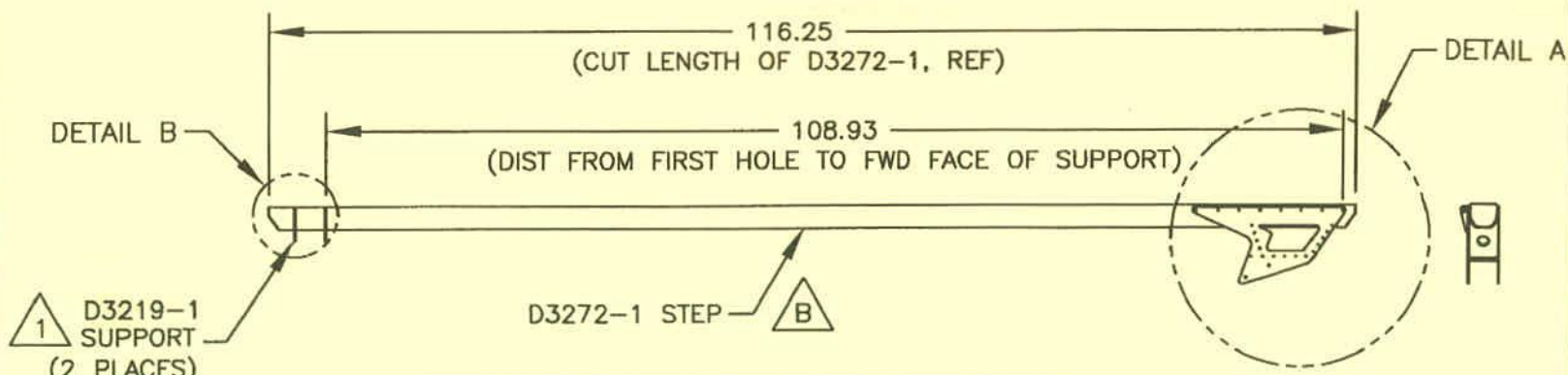
15-5-29

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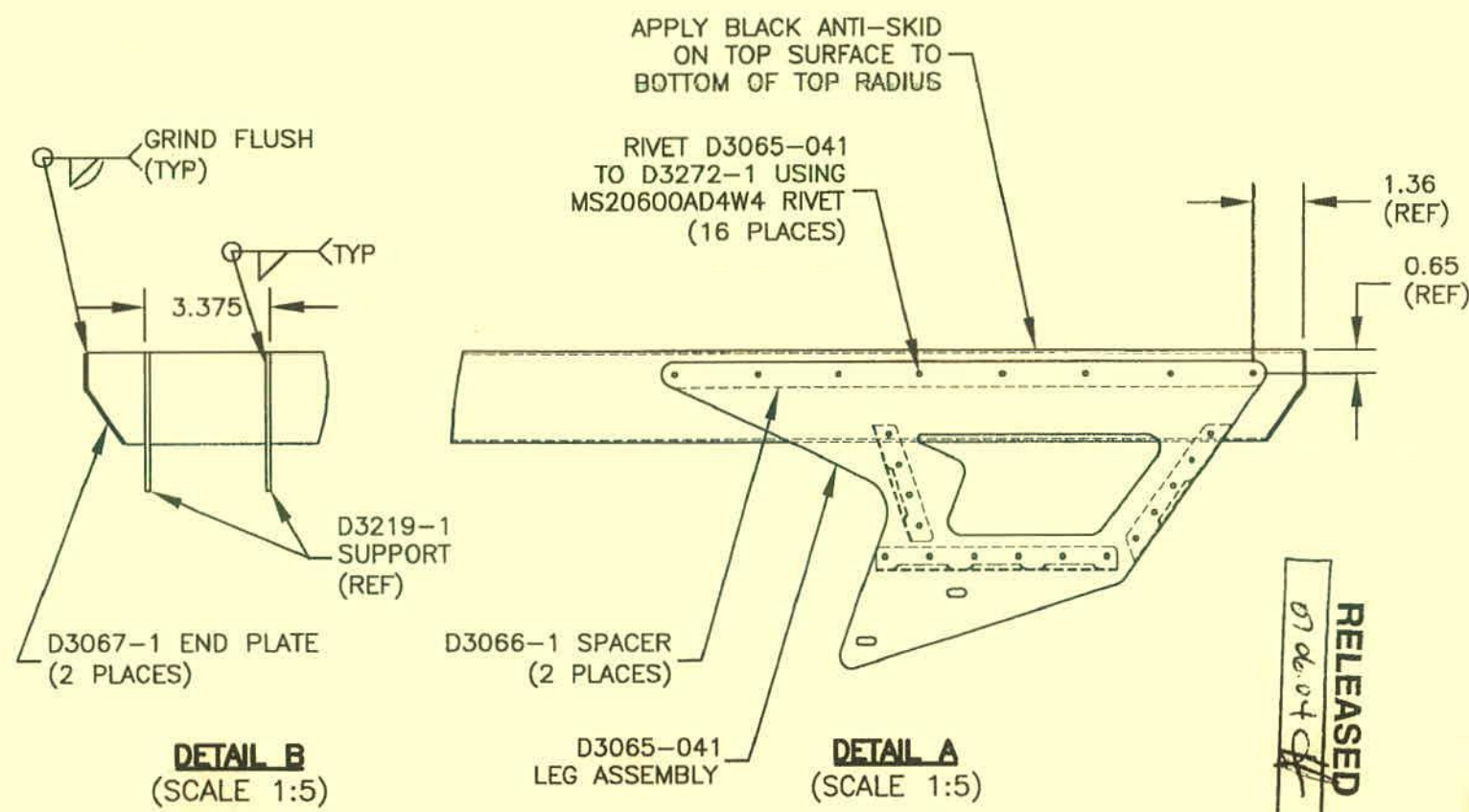
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3 SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



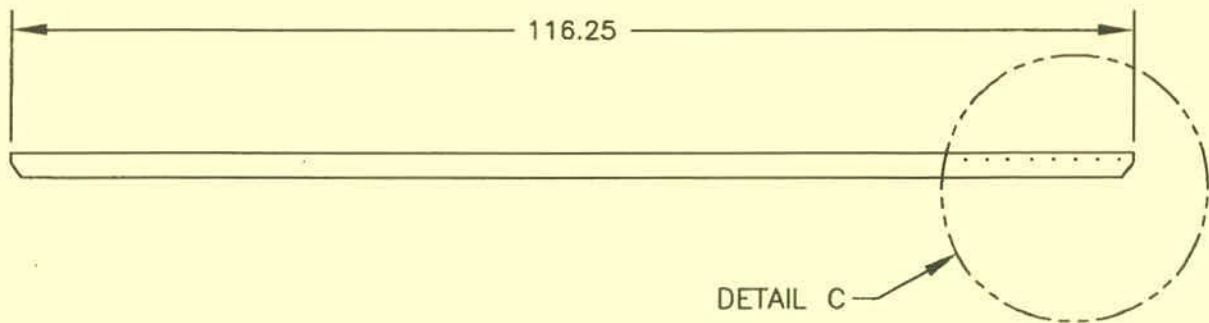
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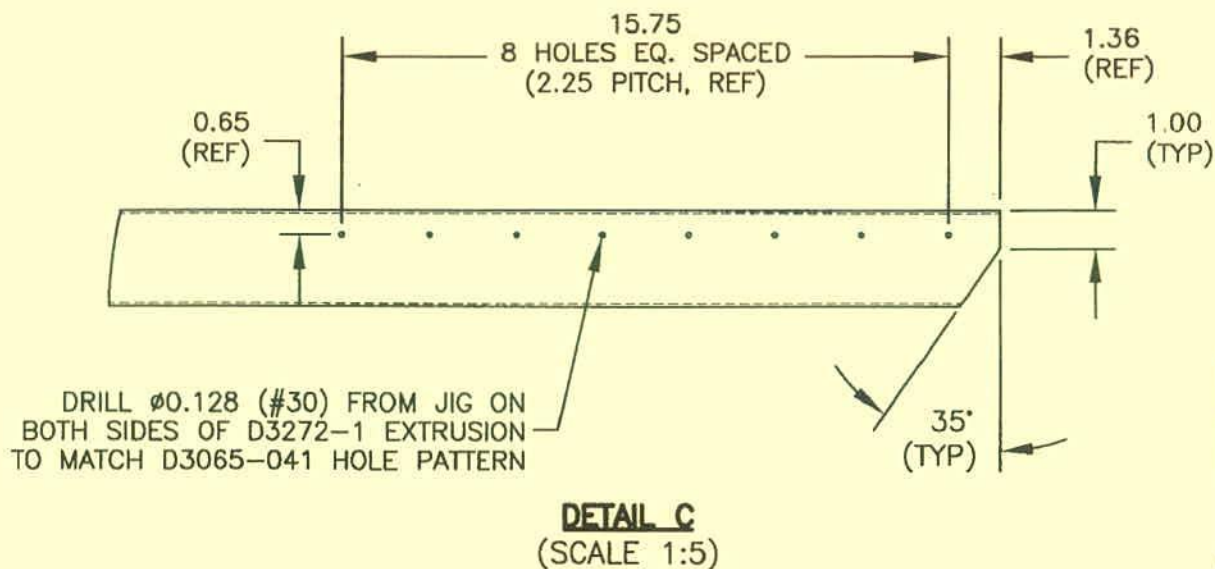


DESIGN	q	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. E
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
				SCALE 1:20

RELEASED
07.06.04



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.